

Work Order ID 160815

Thursday, May 04, 2017 3:00:21 PM

160815

Page 1

Item ID: PB67-43001-259 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Inner Tube
 Start Date: 5/9/2017 Start Qty: 7.00 ***7*** Cust Item ID:
 Required Date: 5/15/2017 Req'd Qty: 7.00 ***7*** Customer:
 Reference: SCHEDULED/U

Approvals: Process Plan: DAS 21 Date: MAY 05 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100		0.00							DAS 13 9-89
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100 Small Fab 7 MAY 23 2017

Small Fab Memo 0.90

Small Fab 1- cut to length as per dwg

2- deburr

110 QC5- Inspect part completeness to step on W/O 0.00

110 QC 7 JUN 05 2017

QC Memo 0.14

Quality Control

120

120 CONVENTIONAL MILLING MACHINE 7 JUN 05 2017

Mill Conv Memo 1.15

Conventional Milling Machine 1- drill hole as per dwg

2- deburr

see 105 read

read + inspect attached spec to w/o M-5-30-7X

SP

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo NIA DAS 38 9-89	0.00 0.14							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: WA3 Memo LOCATION: WA003	0.00 0.07				7	JUN 05 2017	DAS 24 9-89	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.70					17/6/7	JUN 05 2017	70

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
240 US 104								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

Thursday, May 04, 2017 3:00:21 PM

Work Order ID: 160815

160815

Parent Item: PB67-43001-259

PB67-43001-259

Parent Item Name: Inner Tube

Start Date: 5/9/2017

Required Date: 5/15/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.250W.125		Purchased		No		100	f	26.8460	4.7208	34.78484			
M6061T6T1 250W 125									**			MAY 23 2017	DAS 13 9-89
ALUM. RD TUBING 1.250 x.125W													

Location

Loc Qty

Loc Code

MAT

26.846

m132577

12.002

m135249

14.844

m137541 ✓

DQA: _____ Date: _____

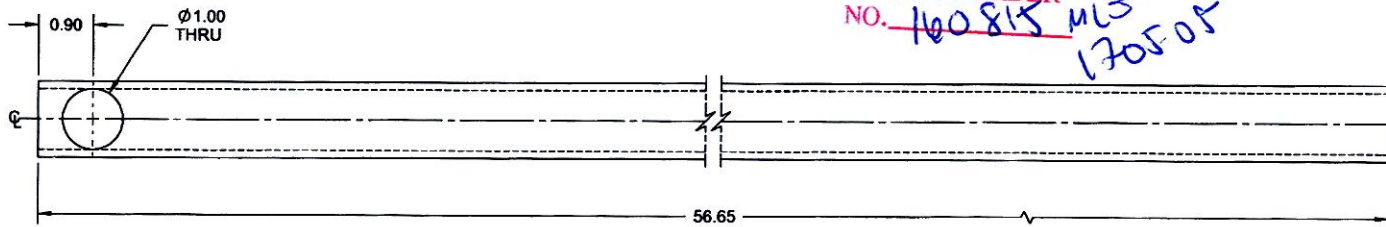
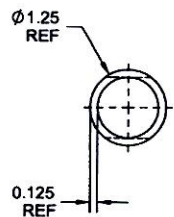


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														



B67-43001-259 INNER TUBE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 160815 MLS
170505

RELEASED
2009-09-24
MB

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T1.250W.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.42 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 24 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR09-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DRAWING NO.		REV. C	
CHECKED	B67-43001-259		SHEET 1 OF 1	
MFG. APPR.	TITLE		SCALE	
APPROVED	INNER TUBE		NTS	
DE APPR.	N/A			
DATE	09.02.27		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36405

Purchase Order Date 5/23/2017

PO Print Date 5/23/2017

Page Number 3 of 5

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613 678 3957

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Total:

\$0.00

6 160815 PB67-43001-259 INNER TUBE 6/7/2017

Yes

6/7/2017

MACHINE AS PER DWG PB67-43001-259
MATERIAL 6061-T6 ROUND TUBING 1.250" X .125" WALL M137541

7.00

\$0.00

\$0.00

DAS
38
9-89

2017-5-30

Line Total:

\$0.00

7 160917 PB67-43001-285 UPPER TUBE 6/7/2017

Yes

6/7/2017

MACHINE AS PER DWG PB67-43001-285
MATERIAL 6061-T6 ROUND TUBING 1.500" X .125" WALL M133966,M135028

5.00

\$0.00

\$0.00

Line Total:

\$0.00

8 160950 PB67-43001-197 OUTER TUBE 6/7/2017

Yes

6/7/2017

MACHINE AS PER DWG PB67-43001-197
MATERIAL 6061-T6 ROUND TUBING 1.750" X 0.065" WALL M137541

7.00

\$0.00

\$0.00

Note:

5/23/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21703
Date: May 29, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 36405	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: May 29, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5159-3 Seat Rib, as per drawing D5159-3 Rev. A	Each	6		6
PB67-43001-127 Handle Arm, as per drawing PB67-43001-127	Each	5	5	0
PB67-43001-257 Inner Tube, as per drawing PB67-43001-257	Each	7	7	
PB67-43001-247 Inner Tube, as per drawing PB67-43001-247	Each	6	6	
PB67-43001-255 Inner Tube, as per drawing PB67-43001-255	Each	7	7	
PB67-43001-259 Inner Tube, as per drawing PB67-43001-259	Each	7	7	
PB67-43001-285 Upper Tube, as per drawing PB67-43001-285	Each	5		5
PB67-43001-197 Outer Tube, as per drawing PB67-43001-197	Each	7		7
PB67-43001-229 Outer Tube, as per drawing PB67-43001-229	Each	7		7
PB67-43001-235 Outer Tube, as per drawing PB67-43001-235	Each	7		7
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>SP14-5-30</u>		Thank you for your order!		

DAS
38
9-88



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

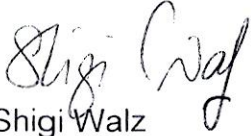
same

Quantity	Part Number	Part Name	Material & Batch #	P.O. Number
7	PB67-43001-257	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541, M13524, M132577	36405
6	PB67-43001-247	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541	36405
7	PB67-43001-255	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541	36405
7	PB67-43001-259	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541	36405

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 29, 2017

DAS
38
9-89